

Thursday, 6/21/2007 1:51:40 PM  
Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CUPPED WASHER
Job Number	: 33093	Part Number	: D36281
Estimate Number	: 12885	Drawing Number	: <del>UNDER REVIEW</del> D3628 REV A
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 6/21/2007 S.O. No. : N/A	Drawing Revision	: U/R
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Due Date	: 6/29/2007
Previous Run	: 32923	Qty:	200 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07-05-28 JLM		

Additional Product

POSITIVE RECALL

EFFECTIVE 07/06/21 AUTH LE  
RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
cut per drwg D3628 Rev.A

07/06/25

(200)

2.0 M304S18GA 304/316 .050 Sheet



Comment: Qty.: 0.0300 sf(s)/Unit Total: 6.0000 sf(s)  
304/316 .050 Sheet  
b 1100997

07/06/25

(200)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



07/06/25

(200)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



ENGINEERING  
APPROVAL

Comment: SECOND CHECK

07/06/26

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



07/06/26



(195)

Comment: SMALL & MEDIUM FAB RESOURCE 1  
FORM PER DRGW D3628 REV.A

07/06/26

(200)

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/06/28

Counted  
(196)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/27

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/27	5	5 piece were scrap	<i>[Signature]</i> 07/06/27	Scrap & destroy	SB 07/06/27	<i>[Signature]</i> 07/06/27	<i>[Signature]</i> 07/06/27	<i>[Signature]</i> 07/06/27

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUPPED WASHER

Job Number: 33093

Part Number: D36281

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

POWDER COATING

POWDER COATING



(196)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BR/M-107-06-28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6/21/29 (196)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

LABEL CODE NO PAINT

Identify with P/N and B/N using a permanent fine point marker on under side of part, then Stock

Location: 51100

6/21/29 (196)

POSITIVE  
RECALL

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(196)

Comment: FINAL INSPECTION/W/O RELEASE

07/06/29

Job Completion



4 07-06-29

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

07/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

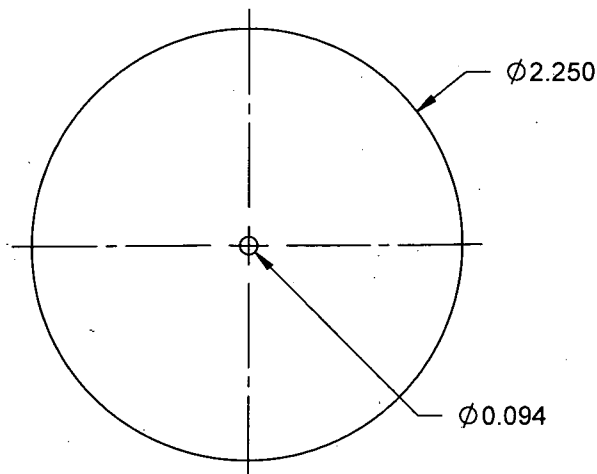
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**PRELIMINARY ISSUE**

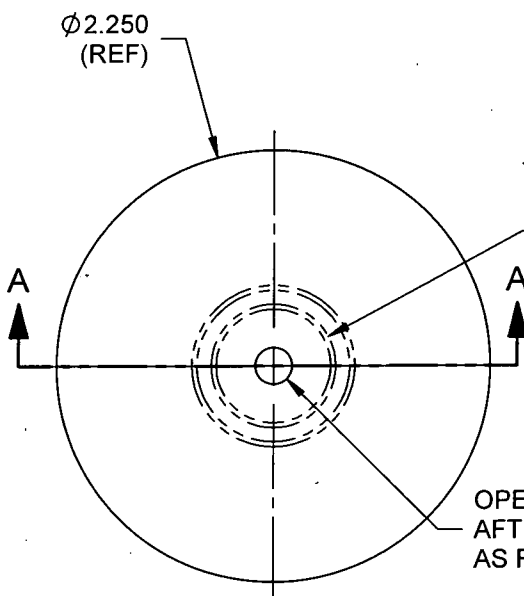
DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CE</b>	APPROVED	DRAWING NO. <b>D3628</b>	REV. A SHEET 1 OF 1
DATE <b>07.06.08</b>	TITLE <b>CUPPED WASHER</b>		SCALE 1:1
REV A	DATE 07.06.08	DESCRIPTION NEW ISSUE	

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. \_\_\_\_\_



**D3628-1F FLAT PATTERN**

PUNCH Ø0.64 x 0.16 DEEP

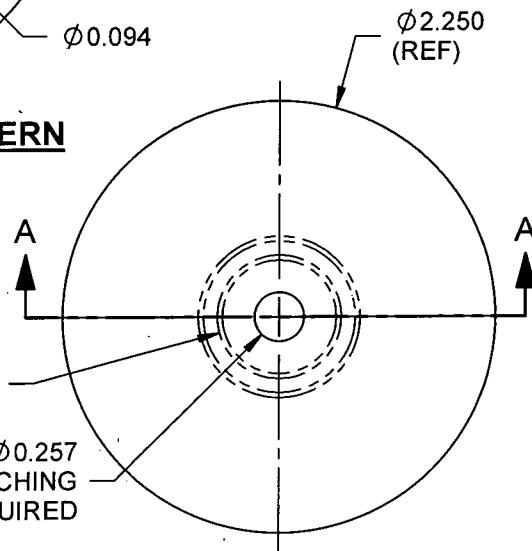


**D3628-1 CUPPED WASHER**  
(MAKE FROM D3628-1F)

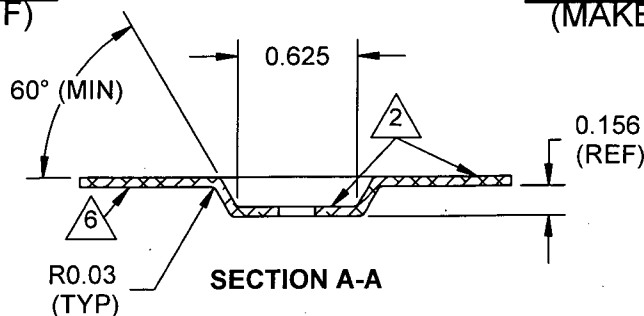
OPEN TO Ø0.191  
AFTER PUNCHING  
AS REQUIRED



OPEN TO Ø0.257  
AFTER PUNCHING  
AS REQUIRED



**D3628-3 CUPPED WASHER**  
(MAKE FROM D3628-1F)



**SECTION A-A**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 ONLY TOP SURFACE AS INDICATED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3628-1/-3" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED
- 7) WHEN DRILLING OUT THE CENTRE HOLE AFTER PUNCHING, ENSURE THAT THE HOLE IS DRILLED CONCENTRIC TO THE CUPPED AREA, WITHIN 0.03

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